

Work Order ID 57741

April 14, 2010 11:35:49 AM



Page 1

Item ID: D2332-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Prop Assembly 6.69" long

Start Date: 14/04/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

PD

Date:

10-4-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2332

Rev C1

100

0.00



Small Fab

Small Fab

Memo

0.00

1- Cut D2332-7 and D2332-5 to length as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

*=> m-l 10/04/28**(10X)*

110

0.00



Brake NC

Brake NC

Memo

0.00

Punch and form D2332-11 to length as per dwg D2332 using DT8012
(need 2 per ass'y)*=> m-l 10/06/09**(10X)*

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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00



Small Fab

Memo

0.00

1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459
(drill one per ass'y)

2- Ensure no foreign objects inside tube

3- Deburr

> m-l 10/06/09

10X

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

D2332-5 - S/w/10 x10

D2332-11 - S/w/10 x10

D2332-7 - S/w/10 x10

D2332-13 - S/w/10 x10

S/w/10

10

140

0.00



Large Fab

Memo

0.00

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)
*****ensure nothing is inside of tube before welding*****

S.S Rod batch: M108160

EZ 10-5-15 10

W/O:		WORK ORDER CHANGES					
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Run Start

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
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Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC9- Inspect visual per QS1004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

10-06-15

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8 10/06/16

10

170

0.00

Small Fab

Memo

0.00

Small Fab

1- Tumble

2- Assemble as per dwg D2332

= 7 m-1 10/06/22

10-06-16

16

10X

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

5/06/22



Quality Control

190

Identify as per dwg & Stock Location: S18

0.00



Packaging

Memo

0.00

10/6/22

100 SF

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/06/23

Quality Control

10/06/23

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Picklist Print

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Page 1

Work Order ID: 57741

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Comments: IPP: B02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304R.250

Purchased

No

100

f

15.4000

1.0526



304 SS Round bar .250

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT028

107387 ✓

15.4

15.4

100

f

41.2137

4.5263

M304TR1.000W.049

Purchased

No



304 RD Tube 1.00 x .049W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT018

1x 108756 ✓

2x 111457 ✓

41.2137

12.08

29.1337

110

f

93.7322

13.1579

M304TR0.500W.035

Purchased

No



304 RD Tube .500 x .035W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT014

114356 ✓

93.7282

93.7282

Main Warehouse

MAT017

112800

0.004

0.004

m-h

1.0526 10/04/21

m-h *

3.16841

10/04/22

0.4526

0.9052

m-h 10/04/20

13.1579

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Required Date: 22/04/2010

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IPP Rev:C 08-06-02 add comment DD verified by:EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-4A		Purchased	No			170	Each	34.0000	10.0000			
Bolt												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST361 34

108138 6

111295 28

AN960JD416L

Purchased

No

170

Each

483.0000

30.0000



Washer



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST346 483

110153 483

~~113910~~

10X m-l 10/06/22

30X m-l 10/06/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4		Purchased	No			170	Each	1,188.000	10.0000			



Nut



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST139	2	
111827	2	
Main Warehouse		
ST300	1186	
113422	194	
114108	984	
9063	8	

M 114718

10x m-l w/06/22

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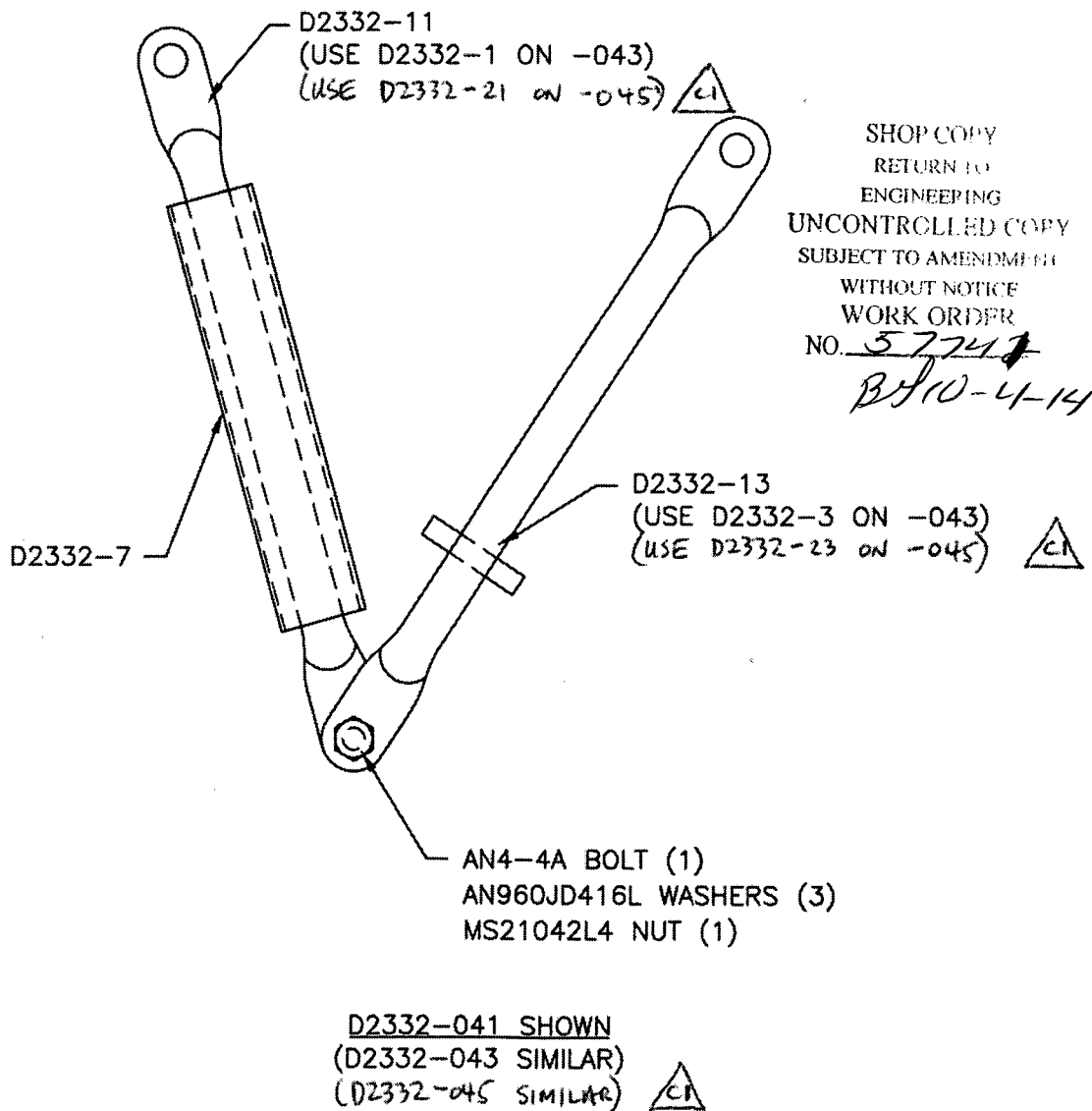
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN <i>[initials]</i>	DRAWN BY <i>[initials]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
CI	<i>[initials]</i> 03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04 *[initials]*

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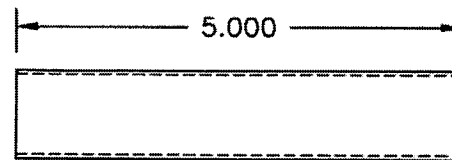
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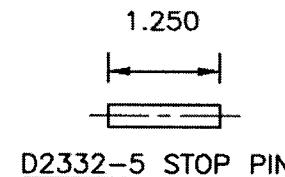
DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
#	#	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	#	D2332
DATE	TITLE	SCALE
03.07.03	LID PROP ASSEMBLY	1:2
C	03.07.03	MAKE - 041 PROP 6.64" LONG (LTD)
C1	03.08.06	MAKE - 043 PROP 8.00" LONG (LTD)
		ADD - 045 PROP 7.25" LONG

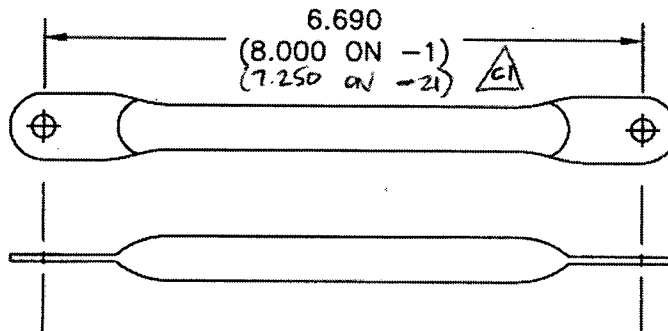


D2332-7 LOCKING COLLAR

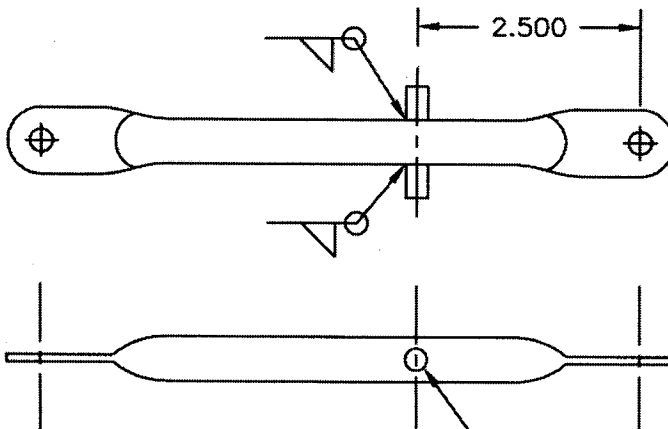


D2332-5 STOP PIN

4057741



D2332-11 PROP
(D2332-1 SIMILAR)



DRILL 1/4 HOLE FOR D2332-5

D2332-13
M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.07.04

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